

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000873**Date Inspected:** 22-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans Mock-Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

The Caltrans QA Inspector observed that welding had been done on Interior Splice Assembly A79, Weld No. 2 on the 114M Mock-Up. The Drawing No. is MUC-A79, Rev. 0. The weld was identified as MUC-A79-2 and is a complete joint penetration (CJP) groove weld welded in the flat (1G) welding position. The welder was Xu Bo (Welder I.D. No. 040427). Welding Procedure Specification (WPS) B-T-2231-TC-U5-F, Rev. 1, for Flux Cored Arc Welding (FCAW) was used for this weld. The Member ID. is A79 - p920.

ZPMC CWI, Chen Xi (CWI No. 07072021) and Bureau Veritas Inspector, Li Wen Sheng were present during all of the above welding.

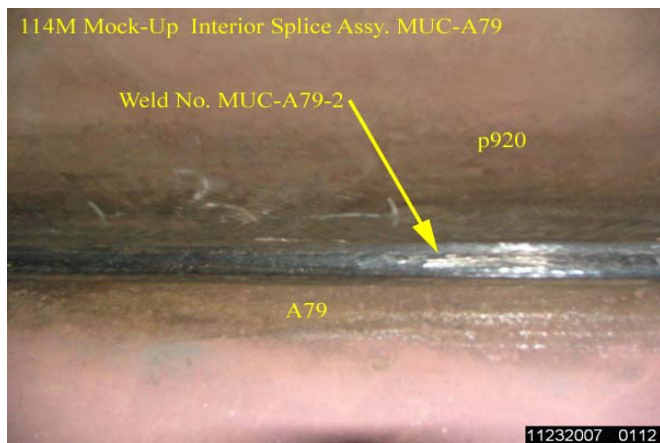
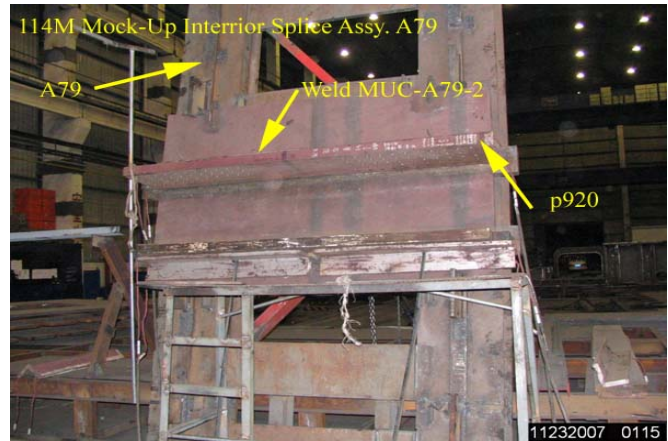
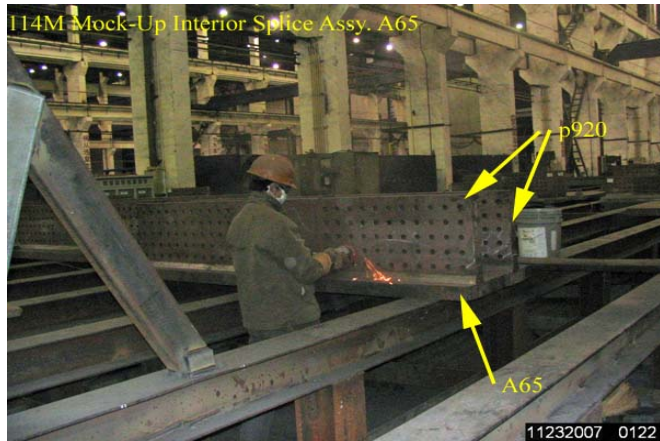
The QA Inspector also observed the grinding/cleaning of Interior Splice Assembly A65, completed Weld Nos. 1 and 2 on the 114M Mock-Up. The Drawing No. is MUC-A65, Rev. 0.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As identified within the contents of this report.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Jobes, Kenneth

Quality Assurance Inspector

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**Reviewed By:** Cochran, Jim

QA Reviewer